Work Order ID 95757 Page 1 January-18-13 10:25:33 AM D3204-3 Item ID: Accept \*N900040100\* Setup Start **Revision ID:** Stop Item Name: Arm **Start Oty: 10.00** 1/16/13 Start Date: Cust Item ID: Required Date: 1/31/13 Req'd Oty: 10.00 Customer: Reference: Run Process Plan: MLJ Date: 13-01-21 Tooling: Approvals: Stop Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Accept Reiect Reject Insp. Work Center ID Oty Number Stamp Description Code Oty **Run Hours** Revision Nbr Draw Nbr D3204 Rev A1 100 0.00 BAND SAW \*100\* C ပ Bandsaw 0.00 Memo Jeaspa Bandsaw Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000) 110 0.00 HAAS CNC VERTICAL MACHINING #1 \*110\* HAAS 1 0.00 Memo HAAS CNC vertical machine #1 1- Machine as per Folio FA344 and Dwg D32042- Deburrldentify as D3204-120 QC2- Inspect parts off machine FAI/FAIB 0.00

0.00

Memo

QC

Quality Control

				•		
DQ	(A:	Date:	 		 	

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	2:
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.	No Scrap Machining Small Fab Prod. Eng. Coor. Use-as-is Thermoforming Finishing Rec/Store/Packaging					Engineering Quality Other					
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process r											
onapproved	1		1 1		F	AULT CATE	GORY		<u> </u>		
Landing	Gear				General		<u> </u>		· · · · · · · · · · · · · · · · · · ·		
	Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W	Crimped. t n Strip in Bend 'aves in E	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Instruct Mainte Mislabe Misreac Offset Out of 0	ion Incomplete tions Incomplete, enance eled d Calibration	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
<b> </b>	Turning S	•		-	Finish	$\vdash$	Sequence				
1	Wave/Tw	ist in Tur	)e		l Folio	1 lOutside	Dimensions				

Work Order ID 95757 Page 2 January-18-13 10:25:33 AM Item ID: D3204-3 Accept \*N900040100\* Setup Start Revision ID: Stop Item Name Arm \*10\* Start Date: 1/16/13 **Start Otv:** 10.00 Cust Item ID: Required Date: 1/31/13 Rea'd Otv: 10.00 \*10\* Customer: Reference: Run Process Plan: \_\_\_\_\_ Date: Tooling: Date: Approvals: Stop QC: \_\_\_\_ Date: SPC (Y/N): Date: Sequence ID/ Tool ID Tool # Plan Reject Reject Operation Set Up/ Accept Insp. Work Center ID Description Code Otv Otv Number Stamp Run Hours OAS 130 QC8- Inspect parts - second check 0.00 \*120\* 13/02/06 OC 0.00 Memo **Ouality Control** 140 Identify as per dwg & Stock Location: 0.00 \*140\* 4.A002 0.00 Packaging

150

Packaging

QC21- Final Inspection - Work Order Release

0.00

\*150\* OC

Memo

0.00

Quality Control

MB027

NCR:	CR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
											QA Closed:	Date	<b>:</b>	
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No.				Rework Scrap Use-as-is	Machining Small Fab		Crosstube Small Fab Finishing	Prod. Eng. Coor.		Engineering Quality Other				
NCR No.				Work Order Update		Hierii	Large Fab	Composite	Rec/Stol	re/Packaging Supplier	Other			
Root					Descri	ption of work order update	1	nitial	Act	ion	Sign &	-		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector	
Doc/Data	Ш													
Equip/Tooling	Ш													
Operator	Ш													
Material	Н													
Setup	Н													
Other	Щ													
Process	Н						1							
Supplier	$\vdash$													
Training Unapproved	Н													
Onapproved	L1	<u>-</u>		<u> </u>	· · · · · ·		<u> </u>	T CATE	EOPV				<u> </u>	
Landi	ng G	iear				General	701	. CAIL	JOKI	·				
		Bending				Bend		Grain			Ovalized	Γ	Pressure/Forced	
	-	Centre No	t Concer	ntric to (		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	${f -}$	Cracks				Broken/Damaged	$\vdash$	1	on Incomplete		Part Incorre	<del> -</del>	Weld	
	П	Crushed/0	Crimped.			Burrs		4	ions Incomplete/L	Inclear	Part Lost/M		Wrong Stock Pulled	
	-	Cuffs	•			Contamination		Mainte			Part Moved	ت ر		
		Heat Trea	t			Countersink		Mislabe			Positioned V	Vrong		
`		Inspection	n Strip in	Tube		Cut Too Short		Misreac	I		Power Loss/		Other	
		Ripples in	Bend			Drill Holes		Offset		<b>L</b>	•			
		Torque W	aves in E	xtrusion	1	Drawing		Out of 0	Calibration					
		Turning So	equence			Finish	Г	Out of S	equence					

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1

Work Order ID:

95757

Parent Item:

D3204-3

Parent Item Name:

Arm

**Start Date: 1/16/13** 

Required Date: 1/31/13

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.000		Purchased	No			100	f	17.1700	0.5538	5.829474			
6061-T6 Bar .500 x 2.00									- A		-,		
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT001		17.17							
				<b></b> ∞ 120′	708	17 17			4		るん	13.02	۶ ی

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Ord	er:					DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No			Rework Skid-tube Crosstube Scrap Machining Small Fab Thermoforming Finishing Work Order Update Large Fab Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other						
			,					<u> </u>					-
Root		i	l			ption of work order update		Initial		ction	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Cr	nief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data	_												
Equip/Tooling	<u> </u>			<u> </u>			j						
Operator	L							1					
Material	<u> </u>												
Setup													
Other	Ŀ												
Process	L												
Supplier									-				
Training													
Unapproved													
						F	AUI	T CATE	GCRY				
Landi	ng (	Gear			·	General		_					_
	L	Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped,			Burrs	Г	Instruct	iors Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved	<u> </u>	_
		Heat Trea	at			Countersink		Mislabe	led		Positioned \	<b>V</b> rong	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss,	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	95757
Description: Arm	Part Number:	D3204-3
Inspection Dwg: D3204 Rev: A1		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototyp	е
---	---------------	----------	---

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.00	+/-0.030	5.991	-		0-6 Jern	8605
5.25	+/-0.030	4.241	-		1	1
0.776	+/-0.010	·776	~			1
Ø0.760	+0.005/-0.000	.761	/			
0.080	+/-0.010	.687	~			
R0.50	+/-0.010	.400				
2.373	+/-0.010	2-375	_			
0.750	+/-0.010	.781	~			
R0.380	+/-0.010	.375	)			
Ø0.375	+0.001/-0.000	. 376	_			
0.300	+/-0.010	,301	_	,	*	d
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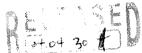
Measured by:	Audited by:	5.0	SAO	Prototype Approval:	N/A
Date: אבי. די ביי	Date:	13/02/06	8-80 0.00	Date:	N/A

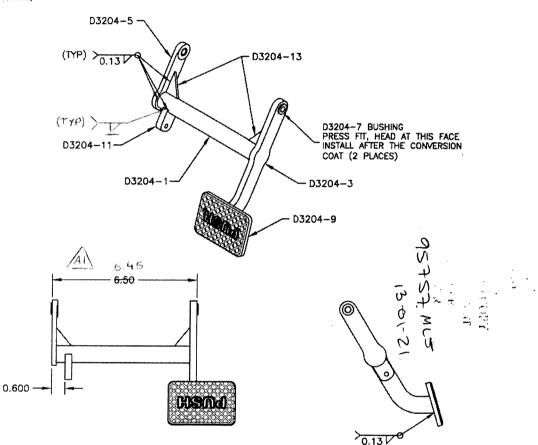
Rev	Date	Change	Revised by	Approved
Α	05.02.17	New Issue	KJ/JLM	1
В	06.03.21	Dwg Rev update	KJ/JLM	ad





1	DESIG	N H	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAD,	
	CHEC	KED,	APPROVED	DRAWING NO.	REV. A
7		#	1	D3204	SHEET 1 OF 3
	DATE			TITLE	SCALE
	04.0	01.27		RELEASE PEDAL ASSEMBLY	NTS
	Α		04.01.27	NEW ISSUE	
	Αi	H-1	- 05.07.15	6.45 WAS 6.50	





## D3204-041 RELEASE PEDAL ASSEMBLY

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125) 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
  6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
  ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
  7) WELD ASSEMBLY PER QSI 004

- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
  10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  11) ALL DIMENSIONS ARE INCHES

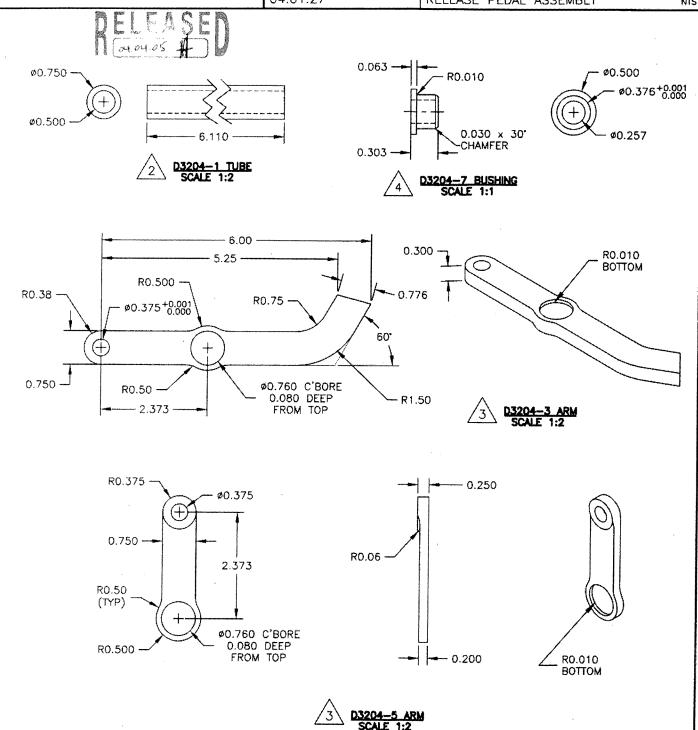
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CHECKED	APPROVED	D3204	REV. A SHEET 2 OF 3
DATE		TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS



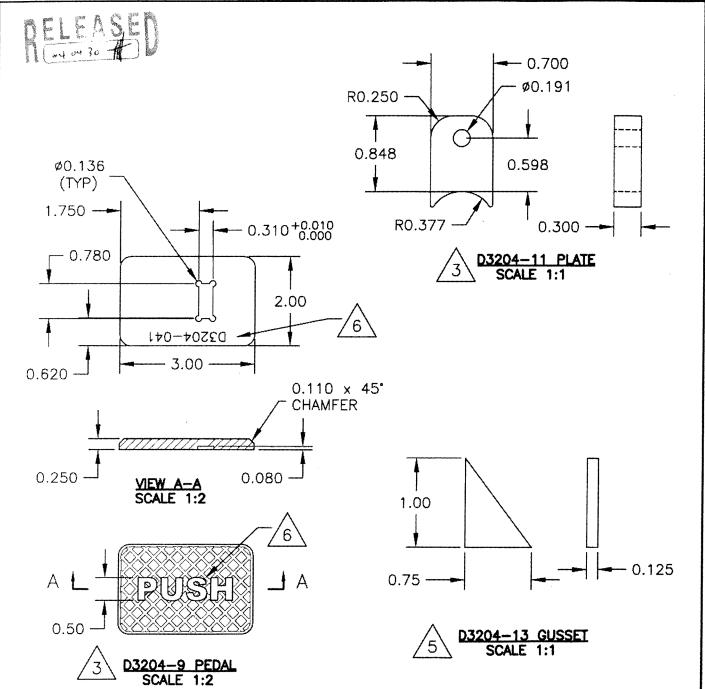
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CHECKED,	APPROVED	DRAWING NO.	REV. A
1	1 -#	D3204	SHEET 3 OF 3
DATE		TILE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS



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